

Date: Tuesday, 9/25/2007 10:13:36 AM
User: Kim Johnston

Process Sheet

split w/lo
07/10/03

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34855 -1
Estimate Number : 11174
P.O. Number : N/A
This Issue : 9/25/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 32285
Written By :
Checked & Approved By :
Comment : Est. B.06.05.25 Added Step 11 KJ/JLM
Est. C 06.05.09 Ecn 798 EC
Est Rev:D Now on Waterjet 06-06-16 JLM

Drawing Name : REPLACEMENT WINDOW ASSEMBLY
Part Number : D3290041
Drawing Number : D3290 UNDER REVIEW
Project Number : N/A
Drawing Revision : B/C PER Ecn# 799 2C
Material : N/A
Due Date : 10/2/2007 Qty: Um: Each

15.
JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M5052H32S040 6061 TC .040 5052-H32 .040 Sheet



Comment: Qty.: 3.9375 sf(s)/Unit Total: 15.7500 sf(s)

5052-H32 .040 Sheet 6061 TC .040

(M5052H32S040)

Batch: M 102723 XB LB 07-10-1 M 100742 X6

2.0 WATER JET 31.5000 FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3290

Dwg Rev: B LB 07-10-1

Prog Rev: B

2-Deburr if necessary LB 07-10-1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-10-02

Date: Tuesday, 07/10/2016 10:50:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 34855

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105068



(14X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/10/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/10/06

(14)

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total : 26.0000 f(s)

Locking Seal

Pick:

Qty Part Number Description
1 D2126-0780 Locking Seal

Batch

B32619 (2) 13P100

B

9.0

D32901

Window Frame



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Window Frame

Pick:

Qty Part Number Description
1 D3290-1 Window Frame

Batch

B34855 2423

SP 02/10/16

17

10.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Window

Pick:

Qty Part Number Description
1 D3290-3 Window

Batch

B29568

07/10/16

(PTU)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAJ 07/10/16

last page
(3)

Date: Tuesday, 9/20/2016 10:10:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 34855

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/26/16

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ref 507/10/16 (3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Ref 507/10/17 (3)

Job Completion

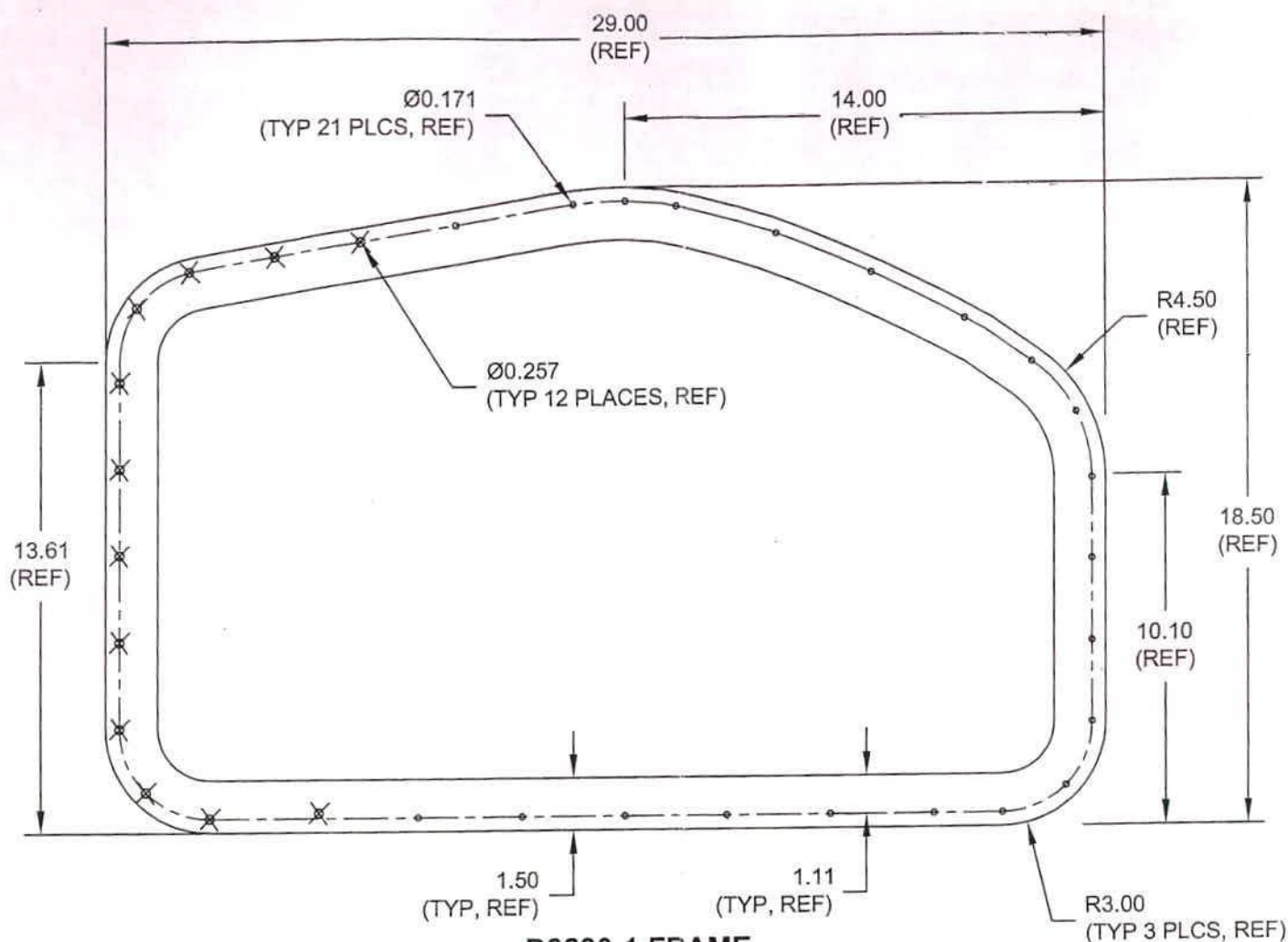


U 07-10-17

☒ First Article ☐ Prototype

Measured by: IB	Audited by: <i>in</i>	Prototype Approval: N/A
Date: 07-10-1	Date: <i>07/10/1</i>	Date: N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

SHOP COPY
RETURN TO
ENGINEERING

RELEASED
07.09.22
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTIC

WORK ORDER
NO. 34852

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3290	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/17	11	Split u/o	SB	27/10/17	3		En Hobbs

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries